

*a* We claim:

CLAIMS.

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15C1-11  
15C127

1. A surface-treating method of a fluorine resin, which comprising subjecting a fluorine resin to surface treatment so that an absorbance at 360 nm is 0.02/100 cm<sup>2</sup> or over when determined by iodometry.

10 2. A surface-treating method of a fluorine resin according to Claim 1, wherein the absorbance is 0.03/100 cm<sup>2</sup> or over.

15 3. A surface-treating method of a fluorine resin, which comprising subjecting the surface of a fluorine resin to corona discharge treatment in a nitrogen gas atmosphere while controlling a concentration of an oxygen gas within a range of 4 to 150 ppm.

20 4. A surface-treating method of a fluorine resin according to Claim 3, wherein the concentration of an oxygen gas is controlled within a range of 4 to 50 ppm.

25 5. A surface-treating method of a fluorine resin, which comprising subjecting a fluorine resin to corona discharge treatment on the surface thereof in air, and further to thermal treatment.

30 6. A surface treating method of a fluorine resin according to Claim 5, wherein the thermal treatment is effected under conditions of 80 to 300°C and 5 to 60 minutes.

35 7. A surface-treating method of a fluorine resin according to any one of Claims 1, 3 and 5, wherein the fluorine resin consists of an ethylene-tetrafluoroethylene copolymer.

8. A method for making a laminate wherein a fluorine resin and a crosslinking elastic adhesive body are directly

bonded together, which method comprising laminating the crosslinking elastic adhesive body to a fluorine resin surface, which has been treated according to one of the following methods (1) to (3):

5       (1) the fluorine resin surface is so treated that its absorbance at 360 nm is 0.02/100 cm<sup>2</sup> or over when determined by iodometry;

10      (2) the fluorine resin surface is treated with corona discharge in an atmosphere of a nitrogen gas while controlling a concentration of an oxygen gas in the range of 4 to 150 ppm; and

15      (3) the fluorine resin surface is treated with corona discharge in air and subsequently thermally treated.

15      9. A method for making a laminate according to Claim 8, wherein after having laminated with the fluorine resin, the crosslinking elastic adhesive body is crosslinked.

20      10. A method for making a laminate according to Claim 8, wherein the crosslinking elastic adhesive body is crosslinked by means of a radical initiator.

25      11. A method for making a laminate according to Claim 8, wherein the crosslinking elastic adhesive body is mainly composed of an ethylene-vinyl acetate copolymer.

30      12. A laminate of the type which comprises a fluorine resin and a crosslinking elastic adhesive body are directly bonded together, wherein the crosslinking elastic adhesive body has a structure including a first crosslinking adhesive body having a content of a silane coupling agent ranging from 0 to less than 0.1 wt% and a second crosslinking elastic adhesive body formulated with a silane coupling agent, and the fluorine resin is directly bonded to one side of the first crosslinking elastic adhesive body and the second crosslinking elastic adhesive layer is directly bonded to the other side.

13. A laminate according to Claim 12, wherein the amount of the silane coupling agent in the second crosslinking elastic adhesive body ranges from 0.1 to 20 wt%.

5 14. A laminate according to Claim 12, wherein the fluorine resin is surface-treated.

15. A laminate according to Claim 12, wherein the fluorine resin is subjected to corona discharge treatment.

10 16. A laminate according to Claim 12, wherein the fluorine resin is surface-treated by one of the following methods (1) to (3):

15 (1) the fluorine resin surface is so treated that its absorbance at 360 nm is 0.02/100 cm<sup>2</sup> or over when determined by iodometry;

20 (2) the fluorine resin surface is treated with corona discharge in an atmosphere of a nitrogen while controlling a concentration of an oxygen gas in the range of 4 to 150 ppm; and

(3) the fluorine resin surface is treated with corona discharge in air and subsequently thermally treated.

17. A laminate according to Claim 12, wherein the first crosslinking elastic adhesive layer is crosslinked by use of a radical initiator.

25 18. A laminate according to Claim 12, wherein the first crosslinking elastic adhesive layer is mainly made of an ethylene-vinyl acetate copolymer.

30 19. A laminate according to Claim 12, wherein the second crosslinking elastic adhesive layer is crosslinked by use of a radical initiator.

20. A laminate according to Claim 12, wherein the second crosslinking elastic adhesive layer is mainly made of an ethylene-vinyl acetate copolymer.

5 21. A laminate according to Claim 12, wherein the fluorine resin is made of an ethylene-tetrafluoroethylene copolymer.

10 22. A method for making a laminate of the type wherein a fluorine resin and a crosslinking elastic adhesive body are directly bonded together, wherein a first crosslinking elastic adhesive body having a content of a silane coupling agent of 0 to less than 0.1 wt% is laminated at one side thereof with the fluorine resin, and a second crosslinking adhesive body formulated with a silane coupling agent is 15 laminated with the other side of the first layer.

20 23. A method for making a laminate according to Claim 22, wherein after having laminated the first crosslinking elastic adhesive body and the second crosslinking elastic adhesive body to the fluorine resin, the first crosslinking elastic adhesive body and the second crosslinking elastic adhesive body are, respectively, crosslinked.

25 24. A method for making a laminate according to Claim 22, wherein the fluorine resin is surface-treated.

30 25. A method for making a laminate according to Claim 22, wherein the fluorine resin is subjected to corona discharge treatment.

26. A method for making a laminate according to Claim 22, wherein the fluorine resin is surface-treated by one of the following methods (1) to (3):

35 (1) the fluorine resin surface is so treated that its absorbance at 360 nm is 0.02/100 cm<sup>2</sup> or over when determined by iodometry;

(2) the fluorine resin surface is treated with corona discharge in an atmosphere of nitrogen gas while controlling a concentration of an oxygen gas in the range of 4 to 150 ppm; and

5 (3) the fluorine resin surface is treated with corona discharge in air and subsequently thermally treated; and the surface-treated fluorine resin is laminated with the first and second crosslinking elastic adhesive bodies and integrally combined.

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27. A method for making a laminate according to Claim 22, wherein the content of the silane coupling agent in the second crosslinking elastic adhesive body ranges from 0.1 to 20 wt%.

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28. A method for making a laminate according to Claim 22, wherein the first crosslinking elastic layer is crosslinked with a radical initiator.

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29. A method for making a laminate according to Claim 22, wherein the first crosslinking elastic layer is made mainly of an ethylene-vinyl acetate copolymer.

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30. A method for making a laminate according to Claim 22, wherein the second crosslinking elastic layer is crosslinked with a radical initiator.

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31. A method for making a laminate according to Claim 22, wherein the second crosslinking elastic layer is made mainly of an ethylene-vinyl acetate copolymer.

32. A method for making a laminate according to Claim 22, wherein the fluorine resin used in this method is made of an ethylene-tetrafluoroethylene copolymer.